

# Work Order ID 68620

Monday, April 18, 2011 3:38:19 PM

Page 1

Item ID: D3028-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Stud

Start Date: 4/18/2011 Start Qty: 8.00

Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-18

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3028

Rev A

100

0:00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn blank per Dwg D3028 and FA263

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Cut groove as per Dwg D3028 and FA

2-Deburr

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

JL 11/04/27

Memo

0.00

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

B.A 11/04/27

Memo

0.00

8

0

150



Outsource3

Outsource process - Cad plate

Outsource process-Cadplate per QSI017 4.1.9.1

0.00

Memo

0.00

Issue P/O: 13986  
Finish : Cadmium plate per QQ-P-416F Class 1, Type II  
Material release note is required.

CZ 11/04/27 (8)

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Page 3

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Required Date: 4/25/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

170

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached  
Identify and Stock

175

ID 4. STOLK

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

(78)

11/5/12 (8)

11/5/12 (80)

11/5/13

11-05-3  
(8)

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# Picklist Print

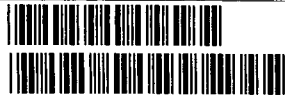
Monday, April 18, 2011 3:38:14 PM

Page 1

Work Order ID: 68620

Parent Item: D3028-1

Parent Item Name: Stud




Start Date: 4/18/2011

Required Date: 4/25/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPPB 02.09.10 Made on Cobra KJ  
IPP C 08.11.06 Added QC6 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NR0.750  4130 steel RD bar .750"		Purchased	No			110	f	12.9200	0.125	1.052632		11/4/25	

Location

MAT031

111823

Loc Qty

12.92

12.92

Loc Code

1.0 LA

W/O:		WORK ORDER CHANGES						
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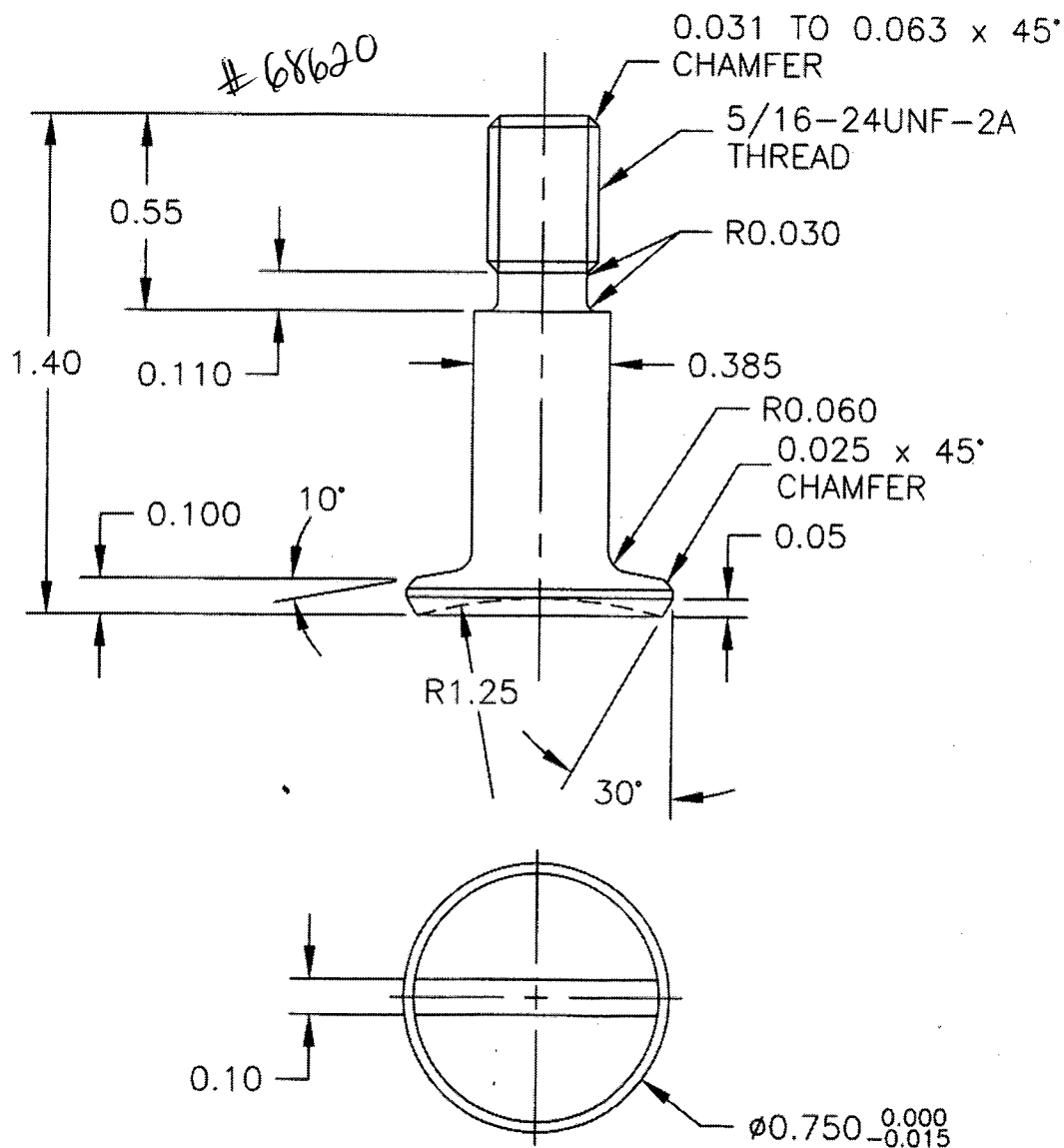
**NOTE:** Date & initial all entries





DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3028	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE STUD	SCALE 2:1
A	01.05.18	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING



D3028-1:

- 1) POSSIBLE SUPPLIER: NORTHERN AERO INDUSTRIES P/N B83602-1
- 2) MATERIAL: AISI 4130N BAR PER MIL-S-6758 OR AMS 6348/6370/6528
- 3) THREADS PER MIL-S-7742
- 4) FINISH: CADMIUM PLATE PER QQ-P-416F CLASS 1, TYPE II
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED  
01.05.30

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO13956**

Purchase Order Date 4/27/2011

PO Print Date 4/27/2011

Page Number 1 of 1

**Order From :**

VC-CAD002

CADORATH COATING  
2150 LOGAN AVE.  
WINNIPEG, MB R2R 0J2  
CA

**Contact Name**

**Vendor Phone**

204 633 9420

**Vendor Fax**

204 633 8033

**Vendor Account Nbr**

**Buyer**

Chantal Lavoie

**Requisition Nbr**

**Tax Resale Nbr**

10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

Destination-Collect

**Ship To :**

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

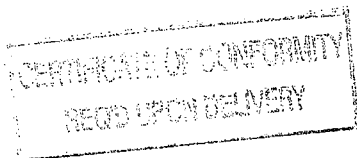
PAID  
(5/10/11)

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	68620	D3028-1 STUD	5/4/2011 Yes	8.00	FedEx PI collect	\$6.9400	\$55.52
		<b>Special Inst:</b>	CAD PLATE AS PER DWG D3028 REV.A CADMIUM PLATE AS PER QQ-P-416F CLASS I, TYPE II				
2	68921	D3028-1 STUD	5/4/2011 Yes	10.00	FedEx PI collect	\$6.9400	\$69.40

**Special Inst:** AS ABOVE

**PO Total:**

**\$124.92**



CL

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 4/27/2011

# Packing Slip



## Cadorath Coating

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

INVOICE NUMBER:

54594

**Sold To:**

Dart Aerospace Ltd.  
1270 Aberdeen St.

Hawksbury, ON K6A 1K7

**ShipTo:**

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Customer Order #:	Date Received:	Terms:	G.S.T. #:	Ship Via:	Ship Date:
13956	Apr-28-2011	NET 30 DAYS	10071 6547 RT0001		Apr-29-2011

Item # Qty P/N & Description

1	8 EA	STUD	S/N B68620
		P/N D3028-1	W/O 104117
2	10 EA	STUD	S/N B68921
		P/N D3028-1	W/O 104118

**CERTIFICATE OF  
CONFORMANCE**

**CADORATH PLATING CO. LTD.  
2150 LOGAN AVENUE  
WINNIPEG, MANITOBA R2J-0J1**

**DATE:** Apr-29-2011

**CONSIGNEE TO:** Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawksbury, ON K6A 1K7

**W/O #:** 104117  
**INVOICE #:** 54594

**CONTRACT OR  
PURCHASE ORDER #**

13956

**DESCRIPTION:** STUD

**QTY** 8

**P/N #** D3028-1

**S/N #** B68620

**CADMIUM PLATED IAW AMS-QQ-P-416C, TYPE 2 YELLOW, CLASS  
1. BAKE HEAT CHART #11-440.**

8 4/5/02

**CERTIFICATE: I certify that the items indicated here on have  
been inspected and tested and conform to all specifications  
and requirements detailed on the contract or purchase order.**

**Approved Inspector:**



A large, stylized handwritten signature in black ink.